



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D350-591-121
Job Sheet 192042



Part No: D350-591-121

Job Qty: 3 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/14/19

Job Tracking No:

Due Date: 4/2/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *stk*

Description: *order #4381*

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time		
110	Large Fab - Steps - 1	3 pcs	4/2/19		0.00	2.04	Large Fab - 1		ML
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	Skidtubes - Bend - 2 - B4B	3 pcs	4/2/19		0.38	0.88	Skidtubes - Bend - B4B		DD
122	QC 5	3 pcs	4/2/19		0.00	0.00	QC 5 - 10		MAR 25 2019 DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Large Fab - Steps - 2 - B4B	3	4/2/19		0.00	2.04	Large Fab - 1 - B4B		

DART

AEROSPACE

Inner No: 513111



D350-591-121

o: 192042

No/Batch: S165172

n:

or:

le:

tions: TC STC SH92-6 Issue 11 Date: 14/03/2019

Dart Aerospace Ltd.

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CANADA

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MAR 26 2019				pcs		0.00 0.00	Large Fab - 10 - B4B	
							Large Fab - 2 - B4B	
							Large Fab - 3 - B4B	
							Large Fab - 4 - B4B	
							Large Fab - 5 - B4B	
							Large Fab - 6 - B4B	
							Large Fab - 7 - B4B	
							Large Fab - 8 - B4B	
							Large Fab - 9 - B4B	
150 QC 9	3	4/2/19	0.00 0.00	pcs			QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	
							QC 9 - 9	
160 QC 5	3	4/2/19	0.00 0.00	pcs			QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
170 Handfinish - 1-1 Chemical- B4B	3	4/2/19	0.00 0.56	pcs			Handfinish - 1 - 1 - B4B	
							Handfinish - 1 - 2 - B4B	
							Handfinish - 1 - 3 - B4B	
							Handfinish - 1 - 4 - B4B	
							Handfinish - 1 - 5 - B4B	
							Handfinish - 1 - 6 - B4B	
							Handfinish - 1 - 7 - B4B	
							Handfinish - 1 - 8 - B4B	
							Handfinish - 1 - 9 - B4B	
							Handfinish - 1 - 10 - B4B	
							Handfinish - 1 - 11 - B4B	
							Handfinish - 1 - 12 - B4B	
							Handfinish - 1 - 13 - B4B	
							Handfinish - 1 - 14 - B4B	
							Handfinish - 1 - 15 - B4B	
							Handfinish - 1 - 16 - B4B	
							Handfinish - 1 - 17 - B4B	
							Handfinish - 1 - 18 - B4B	
							Handfinish - 1 - 19 -	

DAS
24
9-89DAS
43
9-89DAS
43
9-89

→ D.R 19/03/27

				B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 QC 7	3 pcs	4/2/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	DAS MAR 27 2019 68
				QC 7 - 50	9-89
				QC 7 - 67	
				QC 7 - 40	
190 Large Fab - Steps - 3 - B4B	3 pcs	4/2/19	0.00 2.04	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	DAS
				Large Fab - 4 - B4B	24 MAR 28 2019
				Large Fab - 5 - B4B	9-89
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
220 QC 10	3 pcs	4/2/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	DAS
				QC 10 - 50	43
				QC 10 - 58	9-89
				QC 10 - 9	
230 QC 5	3 pcs	4/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	DAS
				QC 5 - 43	43
					9-89

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					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
240 Handfinish - 1-2- Chemical-B4B	3 pcs	4/2/19	0.00 0.56	Handfinish - 1 - 1 - B4B		
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B	D.R 19/03/28	
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
250 Powdercoat - 1 White Gl(A)-B4B	3 pcs	4/2/19	0.00 0.49	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B	BK 19-03-29.	
				Powdercoat - 4 - B4B		
260 Handfinish - 3-1- WingWalk-B4B	3 pcs	4/2/19	0.00 0.56	Handfinish - 3 - 1 - B4B		
				Handfinish - 3 - 2 - B4B	BER 19-03-29.	
				Handfinish - 3 - 3 - B4B		
				Handfinish - 3 - 4 - B4B		
				Handfinish - 3 - 5 - B4B		
270 QC 3	3 pcs	4/2/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
					Plex 3/14/19 2:48 PM Dart.lajeunesse.marie	

					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	DAS APR 02 2019 68
					QC 3 - 9	9-89
					QC 3 - 40	
					QC 3 - 19	
280	Packaging 1-1 - Pick Kit - B4B	3 pcs	4/2/19	0.00 0.00	Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	DAS
					Packaging 1 - 7 - B4B	28
					Packaging 1 - 8 - B4B	9-89
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
290	QC 4	3 pcs	4/2/19	0.00 0.00	QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	DAS
					QC 4 - 46	46 APR 09 2019
300	Packaging 3-1 - Stock - B4B	3 pcs	4/2/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS
					Packaging 3 - 2 - B4B	46 APR 09 2019
					Packaging 3 - 3 - B4B	9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
305 DC - 1 - B4B	3 pcs	4/2/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	APR 11 2019
310 QC 21 - FG	3 pcs	4/2/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	APR 11 2019
				QC 21 - SA - 53	

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Part Op 110 - (Fabricate per Drwg) 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 2- Drill holes as per dwg using Descriptions: DT8230.

120 - (CNC Delta 100 Bender) Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. Use DT8033 jig to make sure bend is good and fits the jig.

122 - (QC5- Inspect part completeness to step on W/O)

140 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod _____ 3-Do not Grind Flush

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Chemical Conversion Coat per QSI005 4.1)

180 - (QC7-Inspect Chemical Conversion Coat)

190 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod _____ 3-Grind end plate flush.

220 - (QC10- Inspect visual per QSI004- ground welds)

230 - (QC5- Inspect part completeness to step on W/O)

240 - (Chemical Conversion Coat per QSI005 4.1)

250 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 7:00 OVEN TEMPERATURE: 320°
FINISH TIME: 8:00 M 138997

260 - (Wing Walk as per dwg QSI005 4.4 Batch 563430)

270 - (QC3- Inspect Part Finish)

280 - (Pick Kit)

290 - (QC4- 100% Inspect kits for completeness)

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

305 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

310 - (QC21- Final Inspection - Work Order Release)

009164

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	1.5000 pcs (.5 ea)	110-Large Fab - Steps - 1	F164533
D2850-1	End Bracket	3 pcs (1 ea)	140-Large Fab - Steps - 2 - B4B	5133680
D2582	Hi-Skid Step Leg Assembly	3 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5153404
D2673-34	End Plate	3 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5161432
MS20600-AD4W3	Cherry Rivet	48 Ea (16 ea)	190-Large Fab - Steps - 3 - B4B	5155768
AN3-37A	Bolt	6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5135486
AN4-13A	Bolt	3 Ea (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5158578
AN4-16A	Bolt	6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5157301
D2230-1	Mounting Lug	3 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5129816
D2230-3	Mounting Lug	3 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5158039
D2732-030	Rubber Cushion - 3"	6 pcs (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5141541
MS21042L3	Nut	6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5157462
MS21042L4	Nut	9 Ea (3 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161468
NAS1149D0363J	Washer	12 Ea (4 ea)	280-Packaging 1-1 - Pick Kit - B4B	5152662
NAS1149D0463J	Washer	18 Ea (6 ea)	280-Packaging 1-1 - Pick Kit - B4B	5157445

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2244-116	2	79	0
140-Large Fab - Steps - 2 - B4B	D2850-1	3	5	0
190-Large Fab - Steps - 3 - B4B	D2582	3	10	0
	D2673-34	3	50	0
	MS20600-AD4W3	48	693	0
280-Packaging 1-1 - Pick Kit - B4B	AN3-37A	6	87	0
	AN4-13A	3	1,815	0
	AN4-16A	6	580	0
	D2230-1	3	311	0
	D2230-3	3	135	0
	D2732-030	6	426	0
	MS21042L3	6	3,616	0
	MS21042L4	9	4,463	0
	NAS1149D0363J	12	855	0
	NAS1149D0463J	18	6,901	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S165172



Part: D350-591-121

Job No: 192042

Serial No/Batch: S165172

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 1d, FAA STC SH967NE 04/12/21, BRAZIL 1

Part Number: D350-591-121

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH

[illegible]